

**Work Order ID 78856****\*78856\***

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Item ID: D407-802-017

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Passenger Door Opener Installation, LH

Start Date: 16/01/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/01/16

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

**\*100\***DOCUMENT CONTROL *80*

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-017 CHG001

105

**\*105\***

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

110

**\*110\***

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

*W 12 01 26 (3)*  
*for MLJ 12-1-18 (3)*

*12/1/18 (3)*

*W 12 01 26 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D407-802-017

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Passenger Door Opener Installation, LH

Start Date: 16/01/2012 Start Qty: 3.00 **\*3\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 3.00 **\*3\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-017								
	Location: _____								
	PPP rev: <u>A</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

b1166 30

12/1/26

CMF  
12-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 78856

\*78856\*

Parent Item: D407-802-017

\*D407-802-017\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC  
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17  
\*D3552-17\*  
Door Prop

Manufactured No

105 Each 21.0000

1

3

\*\*

## Location

## Loc Qty

## Loc Code

ST272

11

64338

4

65120

7

ST276

10

69670

10

105 Each 24.0000

1

3

\*\*

D3622-5  
\*D3622-5\*  
Ball Stud

Manufactured No

## Location

## Loc Qty

## Loc Code

ST058

24

65087

4

76963

20

Manufactured No

105 Each 4.0000

1

3

\*\*

D4108-1  
\*D4108-1\*  
Door Doubler, Left

## Location

## Loc Qty

## Loc Code

st128

4

64484

4

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D407-802-017

\*D407-802-017\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

D4108-049

Manufactured No

105 Each

1.0000

\*D4108-049\*

Litter Door Fitting Assembly

Location

Loc Qty

Loc Code

ST129

1

1

Purchased No

105 Each

137.0000

CR3523-4-03

\*CR3523-4-03\*

RIVET

Location

Loc Qty

Loc Code

ST314

37

112991

10

116373

27

ST331

100

120187

100

Purchased No

105 Each

5,232.000

MS20426AD4-5

\*MS20426AD4-5\*

Rivet

Location

Loc Qty

Loc Code

Mezz

165

6733

165

ST317

5067

6874

5067

Purchased No

105 Each

57.0000

MS21073L5

\*MS21073L5\*

nut plate

Location

Loc Qty

Loc Code

ST302

57

117395

57

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*78856\*

Parent Item: D407-802-017

\*D407-802-017\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

MS21209F1-15

Purchased

No

105

Each

2.0000

\*MS21209F1-15\*

HELI COIL

\*\*

3

9

6x

11/20308

Location

Loc Qty

Loc Code

ST304

2

104537

2

105

Each

56.0000

\*\*

3

9

MS27039C1-06

Purchased

No

\*MS27039C1-06\*

Screw

Location

Loc Qty

Loc Code

ST293

56

115768

56

105

Each

127.0000

\*\*

3

9

MS27039C1-09

Purchased

No

\*MS27039C1-09\*

SCREW

Location

Loc Qty

Loc Code

FP002

28

17831

28

ST293

99

116290

99

105

Each

31.0000

\*\*

2

6

MS27039C1-27

Purchased

No

\*MS27039C1-27\*

Screw

Location

Loc Qty

Loc Code

ST293

31

115768

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 78856

\*78856\*

Parent Item: D407-802-017

\*D407-802-017\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0332R

Purchased

No

105

Each

2,888.000

2

\*NAS1149C0332R\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST297

2888

118354

705

119124

12

119736

2171

NAS1149C1165R

Purchased

No

105

Each

81.0000

2

\*NAS1149C1165R\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST296

81

115768

81

NAS1149C0532R

Purchased

No

105

Each

617.0000

6

\*NAS1149C0532R\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST297

617

116373

1

116513

53

118384

163

119736

400

NAS1149C0563R

Purchased

No

105

Each

294.0000

6

\*NAS1149C0563R\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST297

294

116391

94

117460

200

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

## 5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT